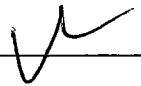


Date: Thursday, 12/04/2007 7:51:43 AM
 User: Linda Lacelle

Process Sheet

| | | | |
|------------------------------------|---|---------------------------|-------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | FWD TUBE ASSEMBLY |
| Job Number : | 31808 | | |
| Estimate Number : | 10467 | | |
| P.O. Number : | N/A | Part Number : | D3391021 |
| This Issue : | 12/04/2007 | Drawing Number : | D3391 REV E |
| Prsht Rev. : | NC | Project Number : | N/A |
| First Issue : | NA | Drawing Revision : | F |
| Previous Run : | 31809 | Material : | N/A |
| Written By : |  | Due Date : | 19/04/2007 |
| Checked & Approved By : | | Qty: | 1 |
| Comment : | Est. A 05.09.13 New issue KJ/JLM | Um: | Each |
| | Est. B 06.02.10 Dwg rev.D ecn 773 EC | | |
| | Est. C 06.05.02 Added inspections EC | | |
| | est D 07.03.13 rev F dwg EC | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------|----------------|
| 1.0 | D6013047 | SKIDTUBE MAT'L |
|-----|----------|----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 SKIDTUBE MAT'L

Pick:

| | | | |
|-----|-------------|-------------|--------|
| Qty | Part Number | Description | Batch |
| 1 | D6013-047 | Extrusion | B26547 |

DP 7-4-12

| | | |
|-----|----------------|-------------------------|
| 2.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1
 Cut extrusion to 46.52 +0.010 -0.020

DP 7-4-12

| | | |
|-----|---------|-----------------|
| 3.0 | BENDING | BENDING MACHINE |
|-----|---------|-----------------|



Comment: Nc bender
 Bend as per Dwg D3391 Using Bend Prog 3391021

EL 7-4-12

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

07-04-12

| | | |
|-----|-------|--------------------------------|
| 5.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine as per Folio FA590 Rev. AA & Dwg D3391 Rev. E
 Identify as D3391

SD 07-04-12

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 12/04/2007 7:51:43 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31808

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Debur

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 07.04.12

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill X1 Aft cap as per Dwg D3391

SD 07.04.12

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 07.04.12

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 07/04/12

10.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill one fwd cap hole to dia.0.128" per DWG D3391 one side only

N/A
07/04/12

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill and c/sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5-Debur

DP
7-4-12

NOTE: Date & initial all entries
H:\FORMS\Quality Assurance\approved QAINCRWO RevD

QA: N/C Closed: _____ Date: _____

[illegible]

Date: Thursday, 12/04/2007 7:51:43 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31808

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

RF 07-04-12

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL 07-04-12 (L)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 07/04/12 (1)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M103706 M-L 07/04/12 (1)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

RF 07-04-12

17.0

NAS1330C3KB166

INSERT



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Rivnut

Pick:

Qty

Part Number

Description

Batch

14

NAS1330C3KB166

Insert

M103278 M-L 07/04/12 (1) P/B

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

M-L 07/04/12 (1)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M-L 07-04-13 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 17.11.17 | | permanent change | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 12/04/2007 7:51:43 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31808

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D3401041

Tow Cap Assembly



①

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Cap Assembly

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 1 | D3401-041 | Tow Cap | B 31346 |

m-l 07/04/14

21.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

22.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

N/A
on this
w/o

23.0

AN3C4A

BOLT



Comment: Qty.: ~~10.0000~~ 4 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------|
| 4 | AN3C4A | Bolt | M 103691 |

✱

24.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

| Qty | Part Number | Description |
|-----|-------------|-------------|
| 4 | NAS1515H3L | Washer |

Batch

M 103641

25.0

AN960C10L

washer



① ✱

Comment: Qty.: 10.0000 Each(s)/Unit Total : ~~10.0000~~ 4 Each(s)

washer

M 103691

m-l 07/04/14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: FD Date: 11/04/16
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 12/04/2007 7:51:43 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31808

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



①

Comment: SMALL & MEDIUM FAB RESOURCE 1

Install tow Cap as per Dwg D3391

Identify as D3391-021

MD 07/04/14

27.0

QC5

INSPECT WORK TO CURRENT STEP



Jan 16 @

Comment: INSPECT WORK TO CURRENT STEP

Inspect thread of each insert using DT8821

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

31709A

29.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

07/04/16

Job Completion



U 07/04/16

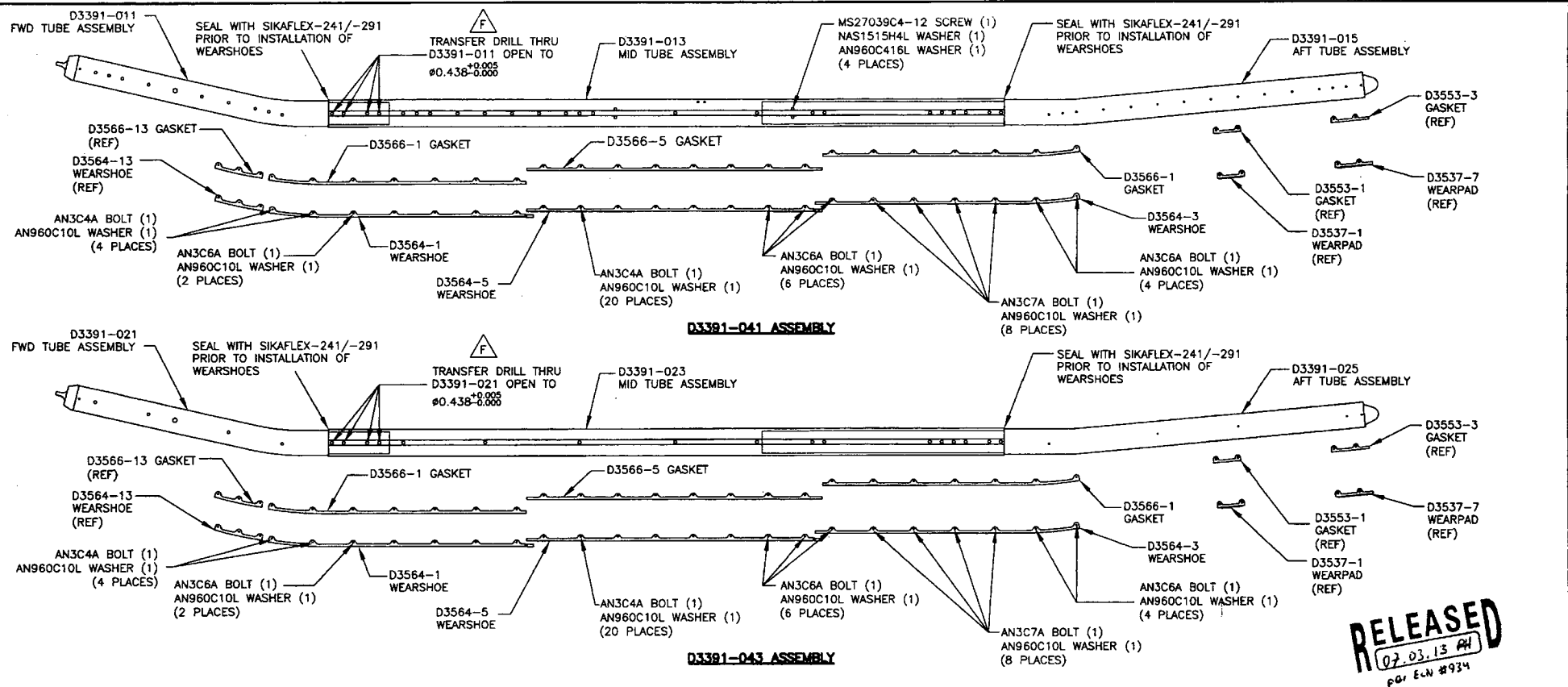
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

| QTY -041 | QTY -043 | PART NUMBER | DESCRIPTION |
|----------|----------|--------------|-------------------------|
| X | X | D3391-041 | FLOAT SKIDTUBE ASSEMBLY |
| | | D3391-043 | FLOAT SKIDTUBE ASSEMBLY |
| 1 | | D3391-011 | FWD TUBE ASSEMBLY |
| 1 | | D3391-013 | MID TUBE ASSEMBLY |
| 1 | | D3391-015 | AFT TUBE ASSEMBLY |
| 1 | | D3391-021 | FWD TUBE ASSEMBLY |
| 1 | | D3391-023 | MID TUBE ASSEMBLY |
| 1 | | D3391-025 | AFT TUBE ASSEMBLY |
| 1 | 1 | D3566-1 | WEARSHOE |
| 1 | 1 | D3566-3 | WEARSHOE |
| 1 | 1 | D3566-5 | WEARSHOE |
| 2 | 2 | D3566-1 | GASKET |
| 1 | 1 | D3566-5 | GASKET |
| 24 | 24 | AN3C4A | BOLT |
| 12 | 12 | AN3C6A | BOLT |
| 8 | 8 | AN3C7A | BOLT |
| 44 | 44 | AN960C10L | WASHER |
| 4 | | MS27039C4-12 | SCREW |
| 4 | | NAS1515H4L | WASHER |
| 4 | | AN960C416L | WASHER |

GENERAL NOTES

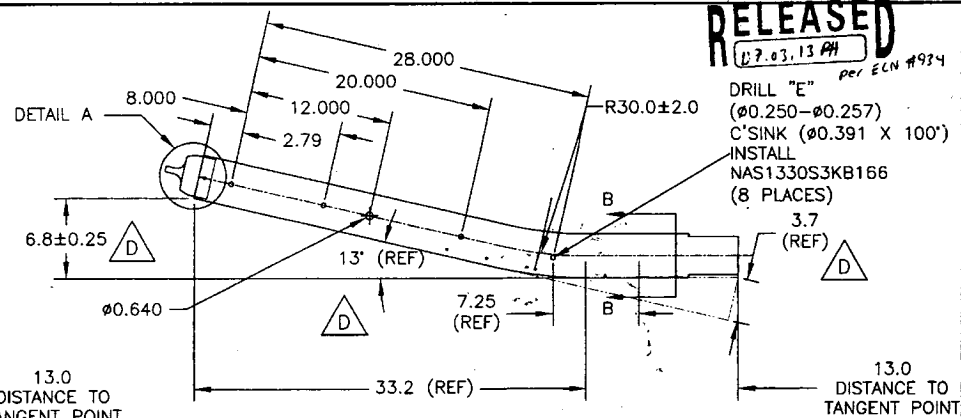
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (Ø0.250-Ø0.257) FOR WEARSHOE INSERTS. C'SINK Ø0.391/Ø0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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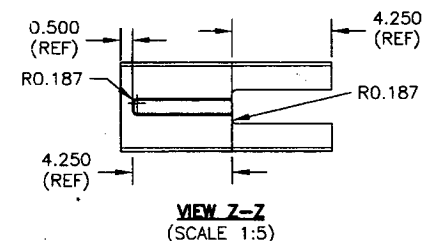
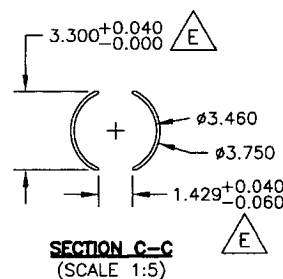
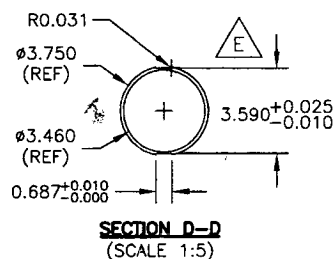
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| | | |
|----------|----------|---|
| F | 07.01.18 | ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021 |
| E | 06.04.25 | CHANGE TOLERANCE, EASE MANUFACTURE |
| D | 06.01.23 | UPDATE TOLERANCE, CHANGE HOLE SIZE |
| C | 05.09.27 | LENGTHEN AFT EXTENSION |
| B | 05.06.10 | DRAWING UPDATES |
| A | 05.02.07 | NEW ISSUE |
| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. PORT HADLOCK, MA |
| CHECKED | APPROVED | DRAWING NO. D3391 |
| DATE | | TITLE 412 FLOAT SKIDTUBE |
| 07.01.18 | | SCALE NTS |

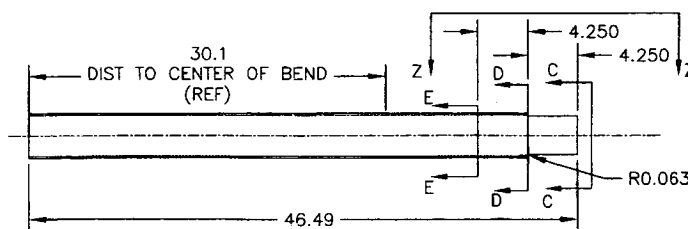
RELEASED
07.03.13 AH
per E.N. #934




D3391-021 ASSEMBLY AND BENDING DETAIL



VIEW Z-Z
(SCALE 1:5)






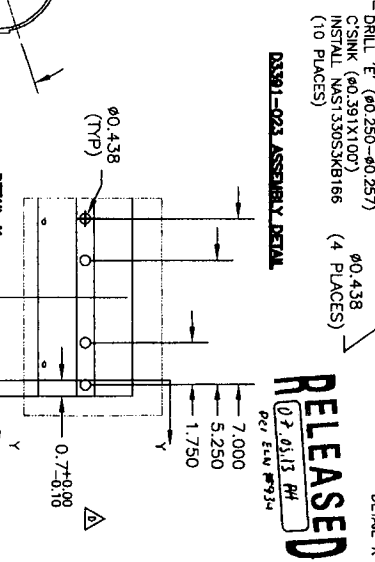
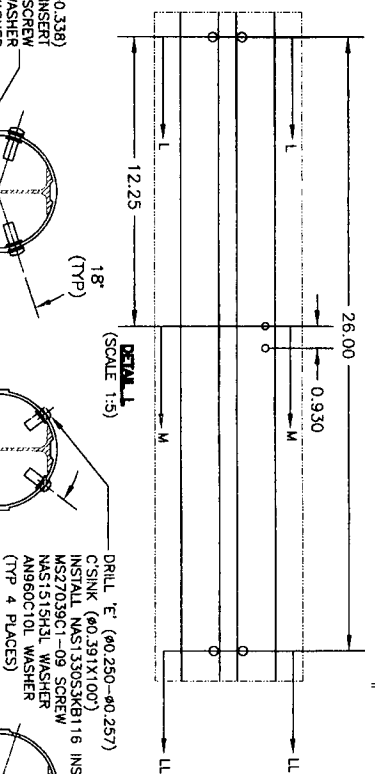
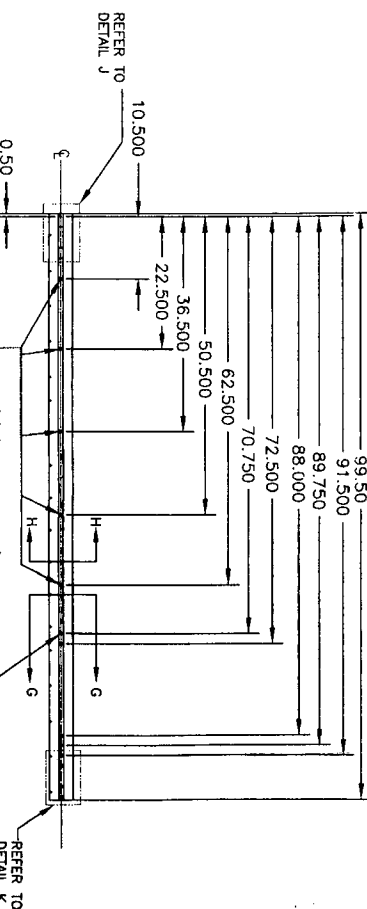
D3391-1 DRILLING AND CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)


 DRILL "E"
 (Ø0.250-Ø0.257)
 C'SINK (Ø0.391 X 100')
 INSTALL
 NAS1330S3KB166
 (12 PLACES)

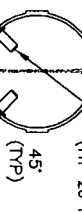
SECTION B-B
 (SCALE 1:5)


| QTY - 011 | QTY - 021 | PART NUMBER | DESCRIPTION |
|-----------|-----------|----------------|----------------------------|
| X | | D3391-011 | FWD TUBE ASSEMBLY |
| | X | D3391-021 | FWD TUBE ASSEMBLY |
| 1 | 1 | D6013-047 | FWD TUBE |
| 1 | 1 | D3401-041 | TOW CAP |
| 1 | 1 | D3564-13 | WEARSHOE |
| 1 | 1 | D3566-13 | GASKET |
| 10 | 10 | AN3C4A | BOLT |
| 4 | 4 | NAS1515H3L | WASHER |
| 10 | 10 | AN960C10L | WASHER |
| 30 | 20 | NAS1330S3KB166 | INSERT (OR NAS1330C3KB166) |

| | | | | | |
|--|--|--|---|---|------------------------|
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| DATE 07.01.18 | | TITLE 412 FLOAT SKIDTUBE | | | SCALE 1:10 |

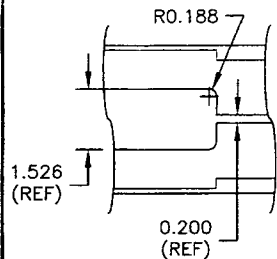


(RE)

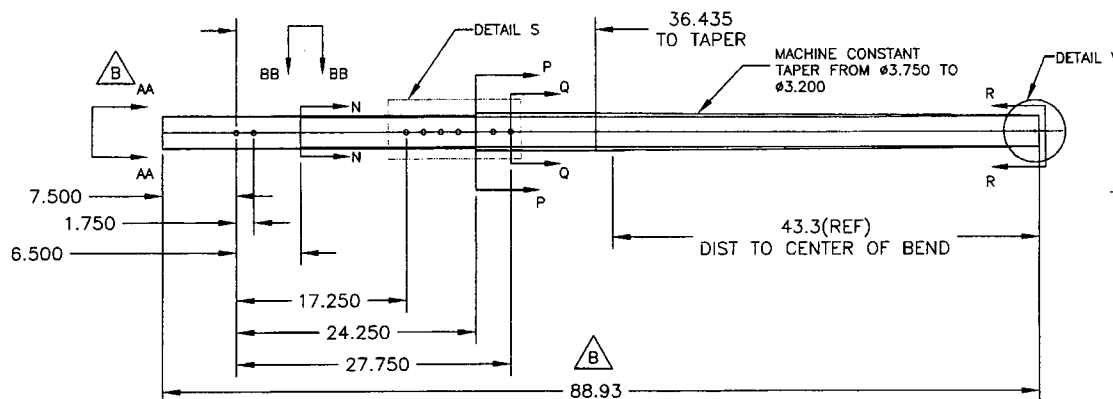


| | | | |
|---|----------------------------------|------------------------|-----------------------|
|  DART AEROSPACE USA, INC. PORT HADLOCK, MA | | DESIGN BY <i>PH</i> | DRAWN BY <i>PH</i> |
| CHECKED <i>PH</i> | APPROVED <i>PH</i> | DRAINING NO. D3391 | |
| DATE 07.01.18 | TITLE 412 FLOAT SKIDTUBE | REV. SHEET 3 OF | SCALE 1:2 |

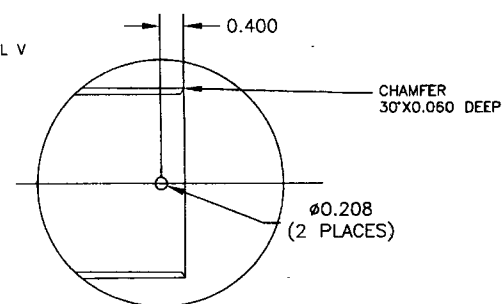
RELEASED
07.05.13 PM
DOL EN 934



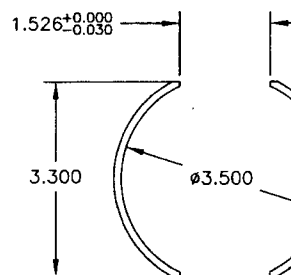
VIEW BB-BB
(SCALE 1:3)



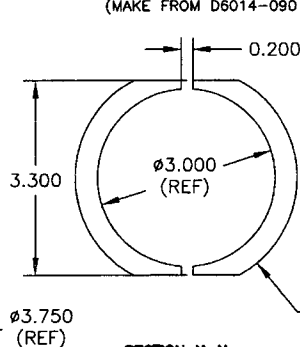
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



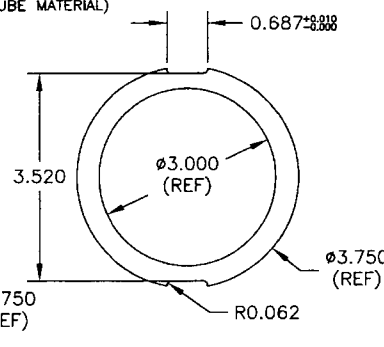
DETAIL V
(SCALE 1:2)



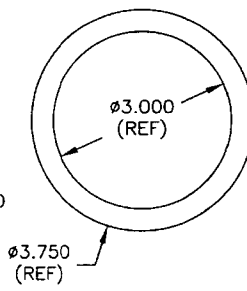
SECTION AA-AA
(SCALE 1:2)



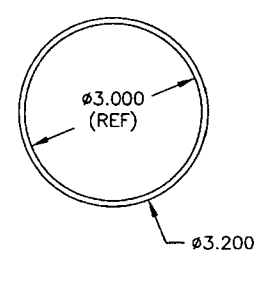
SECTION N-N
(SCALE 1:2)



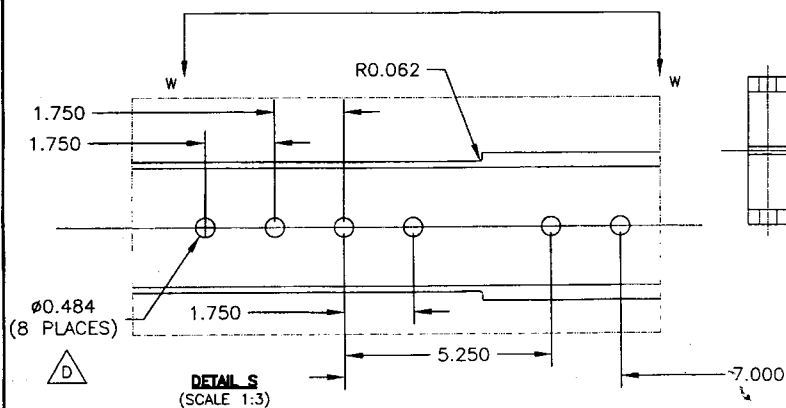
SECTION P-P
(SCALE 1:2)



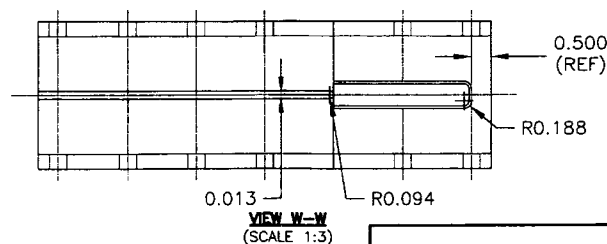
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)



VIEW W-W
(SCALE 1:3)

RELEASED
07-05-13 AH
PCE ELN #934

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| | | |
|------------------|-----------------------------|--|
| DESIGN D4 | DRAWN BY D4 | DART AEROSPACE USA, INC. PORT HADLOCK, MA |
| CHECKED # | APPROVED # | DRAWING NO. D3391 |
| DATE 07.01.18 | TITLE 412 FLOAT SKIDTUBE | REV. F SHEET 4 OF 5 SCALE 1:12 |



| QTY - 015 | QTY - 025 | PART NUMBER | DESCRIPTION |
|-----------|-----------|----------------|----------------------------|
| X | | D3391-015 | AFT TUBE ASSEMBLY |
| | X | D3391-025 | AFT TUBE ASSEMBLY |
| 1 | 1 | D6014-090 | AFT TUBE |
| 1 | 1 | D2846 | AFT CAP |
| 1 | 1 | D3537-1 | WEARPAD |
| 1 | 1 | D3537-7 | WEARPAD |
| 1 | 1 | D3553-1 | GASKET |
| 1 | 1 | D3553-3 | GASKET |
| 18 | 14 | NAS1330S3KB366 | INSERT (OR AES10KB366) |
| 4 | 2 | NAS1330S3KB316 | INSERT (OR NAS1330C3KB316) |
| 8 | 6 | NAS1330S3KB266 | INSERT (OR NAS1330C3KB266) |
| 4 | | NAS1330S3KB216 | INSERT (OR NAS1330C3KB216) |
| 16 | 12 | NAS1330S3KB166 | INSERT (OR NAS1330C3KB166) |
| 4 | | NAS1330S4KB151 | INSERT (OR NAS1330C4KB151) |
| 6 | 6 | AN3C4A | BOLT |
| 4 | 4 | AN3C5A | BOLT |
| 2 | 2 | NAS1515H3L | WASHER |
| 10 | 10 | AN960C10L | WASHER |



DRILL 'Q' (Ø0.332-Ø0.338)
C'SINK (Ø0.529X100")
NAS1330S4KB151 INSERT (1)
(4 PLACES)



AN3C4A BOLT (1)
NAS1515H3L WASHER (1)
AN960C10L WASHER (1)
(2 PLACES)

D2646 AFT CAP

DETAIL 1

SEAL WITH
SIKAFLEX-241/-291

C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

| HOLES MARKED | QTY D3391-015 | QTY D3391-025 | C'SINK | P/N |
|-----------------|------------------|------------------|--------|----------------|
| CS1 | 18 | 14 | Ø0.425 | NAS1330S3KB366 |
| CS2 | 4 | | Ø0.391 | NAS1330S3KB366 |
| CS3 | 4 | 2 | Ø0.391 | NAS1330S3KB316 |
| CS4 | 8 | 6 | Ø0.391 | NAS1330S3KB266 |
| CS5 | 4 | | Ø0.391 | NAS1330S3KB216 |
| CS6 | 16 | 12 | Ø0.391 | NAS1330S3KB166 |

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REV. 1

SHEET 5 OF 5

SCALE
1:1:

